

Date: Friday, 5/25/2007 12:52:09 PM
 User: Kim Johnston

Process Sheet

29

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
 Job Number : 32684
 Estimate Number : 10257
 P.O. Number : N/A Part Number : D212664201
 This Issue : 5/25/2007 S.O. No. : N/A Drawing Number : D212-664-241 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 32683 Material : N/A
 Due Date : 7/15/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JA 07.05.28
 Comment : Est Rev:E 04.02.16 Reformat K/DS
 Est Rev:F 06-03-29 Remove Coments on Pick List JLM
 Est Rev:G 07-04-30 As per Rev C JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

2F 07/06/30

2.0 D6006129 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube B25666

Check OD = 3.250"; ID = 2.220"

2F 07/06/30

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

2F 07/06/30

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

2F 07/07/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:52:09 PM
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

JS 07/07/02 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JS 07/07/02 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/07/03 ①

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

mk 07/07/03 ①

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-7-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JD 07/07/02 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

JD 7-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 32684

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/24 (41)

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

EL 7-7-24

14.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

212-25 @

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

DP/10
7-8-1
7-8-2

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

JO 7-8-2

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 07/08/10

(1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/10

19.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 4338

LPI as per ASTM 1417 Level 2

6267/08/10 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 32684

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



CG 07/08/14

(1)



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

EP 07/08/14 x1

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ML 07 08 14

(1)

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

RT 07-08-15

24.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1

Support

33560

RT 07-08-15

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0242 sf(s)/Unit Total : 0.0242 sf(s)

Rubber Cushion (per sq ft)

.63" x 5.300

Batch:

33834

CT 07-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 32684

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

107896

8T 07-08-15

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 104723

Expiry Date: 08-10-01

8T 07-08-15
3:00

2-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

8T 07-08-17

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8T 07/08/17 (X1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 626249-

EP

31.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104374-

EP

8T 07/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 32684

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN641A

Bolt



EP



Er Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M100743-*

33.0

AN960JD616

Washer



EP



Er Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: *M104374-*

34.0

MS21042L6

Nut



EP



Er Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: *M101660-*

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



EP 07/08/17 @
Er 07/08/17



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



REV: C



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

EP 2/8/12 SP

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32684
Description: Crosstube Assembly (205/212 High Aff)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: <i>BC</i> <i>07.05.24</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

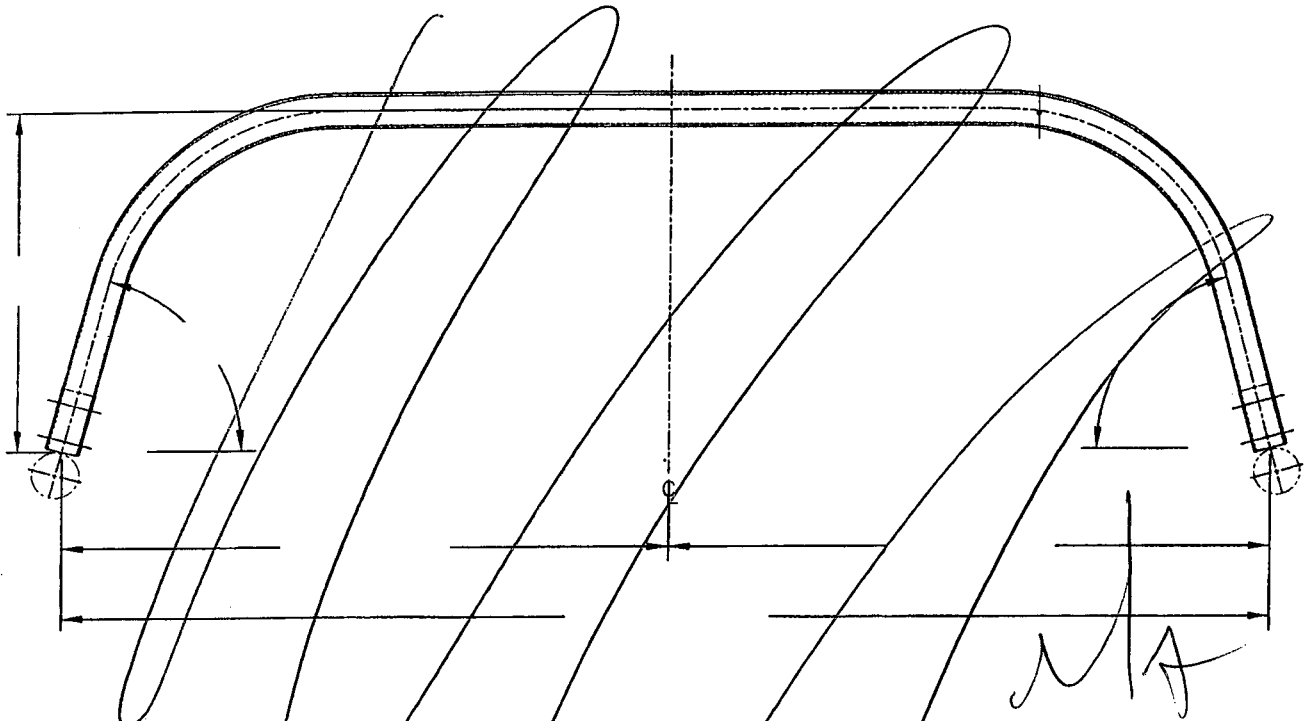
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	<i>.210</i>				
	R0.063	+/-0.010	<i>.063</i>				
	2.990	+0.005/-0.000	<i>2.992</i>				
	5.237	+/-0.030	<i>5.250</i>				
	2.600	+0.005/-0.000	<i>2.602</i>				
	2.686	+0.005/-0.000	<i>2.688</i>				
	2.770	+0.005/-0.000	<i>2.772</i>				
	2.854	+0.005/-0.000	<i>2.856</i>				
	2.938	+0.005/-0.000	<i>2.940</i>				
	3.021	+0.005/-0.000	<i>3.023</i>				
	3.133	+0.005/-0.000	<i>3.135</i>				
	3.179	+0.005/-0.000	<i>3.181</i>				
SIDE B	0.200	+/-0.010	<i>.210</i>				
	R0.063	+/-0.010	<i>.063</i>				
	2.990	+0.005/-0.000	<i>2.992</i>				
	5.237	+/-0.030	<i>5.250</i>				
	2.600	+0.005/-0.000	<i>2.602</i>				
	2.686	+0.005/-0.000	<i>2.688</i>				
	2.770	+0.005/-0.000	<i>2.772</i>				
	2.854	+0.005/-0.000	<i>2.856</i>				
	2.938	+0.005/-0.000	<i>2.940</i>				
	3.021	+0.005/-0.000	<i>3.023</i>				
	3.133	+0.005/-0.000	<i>3.131</i>				
	3.179	+0.005/-0.000	<i>3.181</i>				
	124.36	+/-0.020	<i>124.36</i>				

Measured by: <i>JS</i>	Audited by: <i>ml</i>	Prototype Approval:	N/A
Date: <i>07/06/30</i>	Date: <i>07/07/03</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	<i>JS</i>
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	<i>JS</i>

DART AEROSPACE LTD		Work Order:	32684
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241	Rev: <i>EC</i> 07.05.28	Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.36
1/2 Span	53.66	53.78
Angle	49	52
Total Span	107.32	107.56



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED
07.04.24 P
PER E.C.N. 2059

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

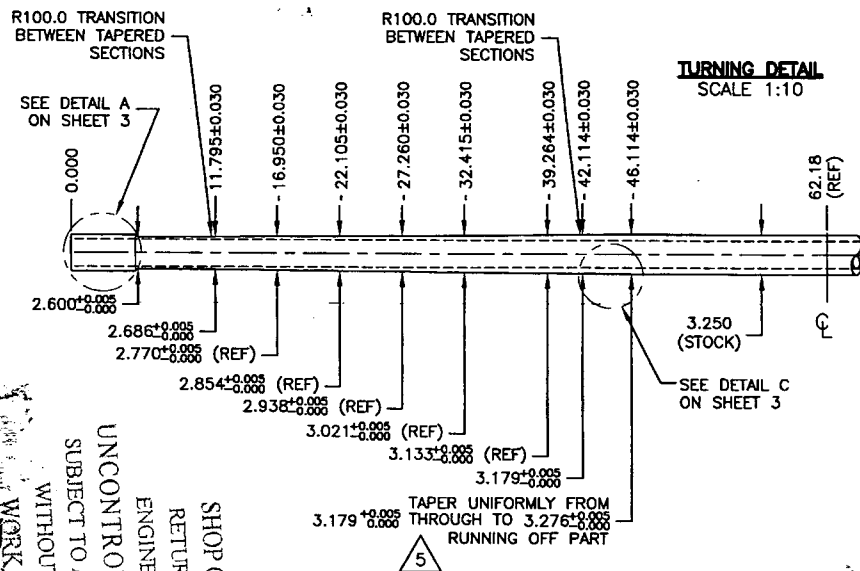
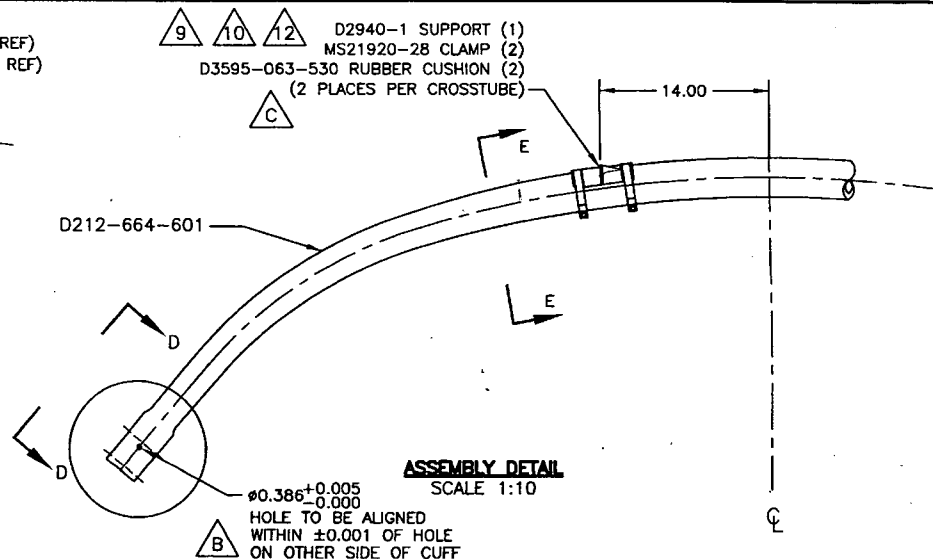
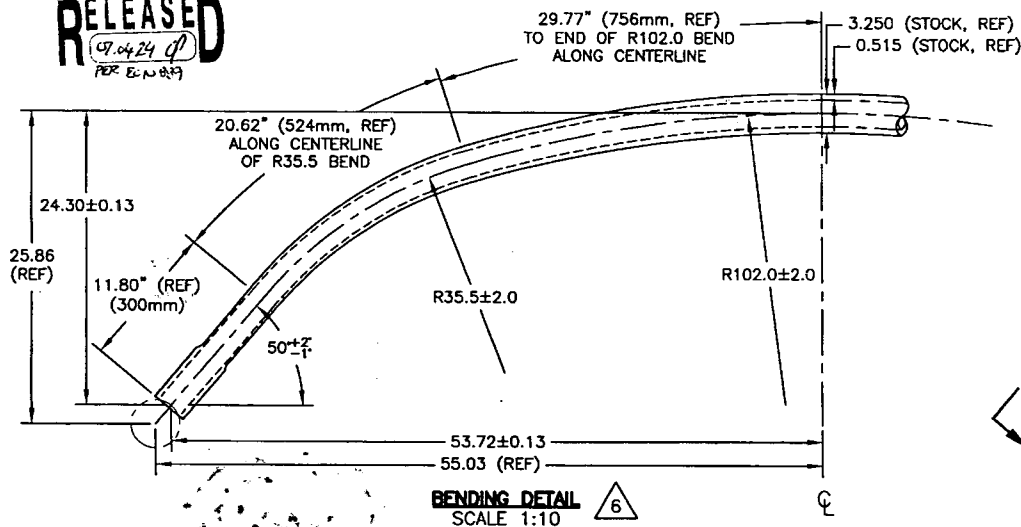
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
FOR THE LED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO **32684**

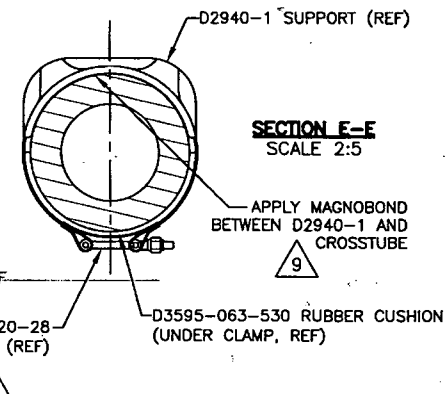
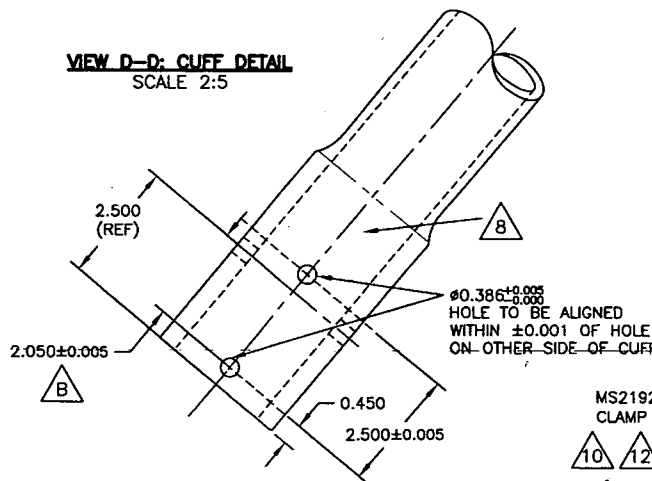
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RELEASED
07.04.24
PER E-N 047



VIEW D-D: CUFF DETAIL
SCALE 2:5



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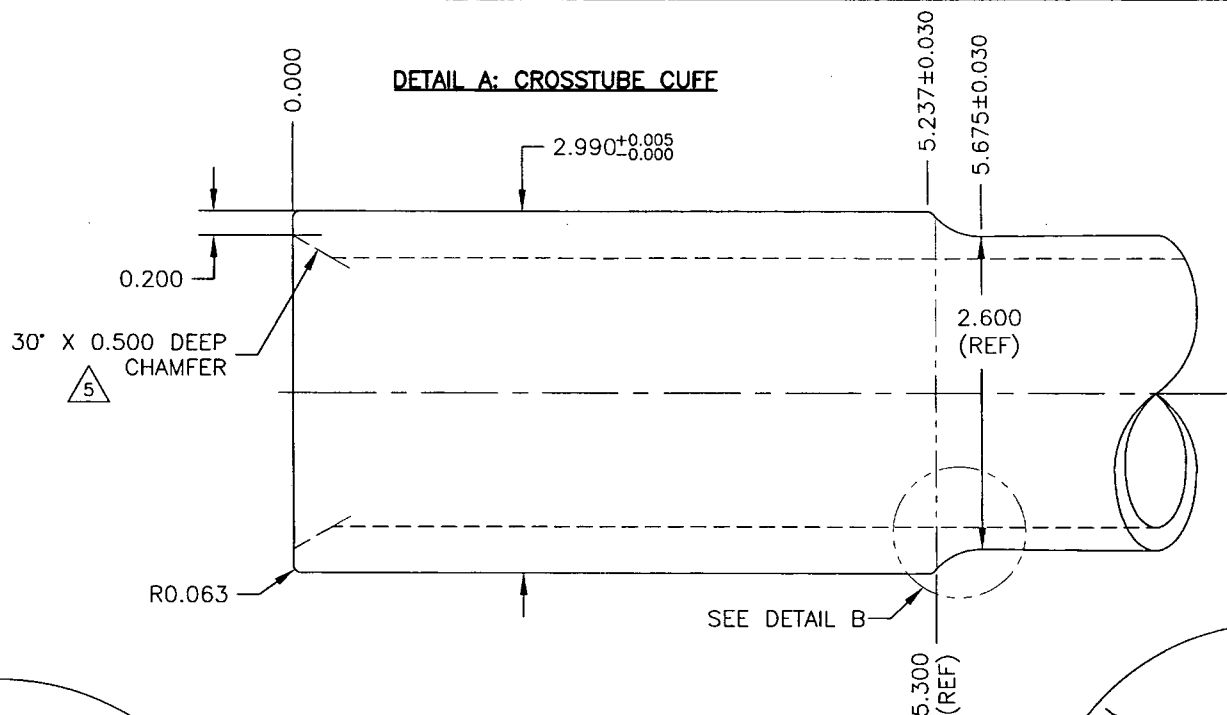
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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED J	APPROVED A	DRAWING NO. D212-664-241	REV. C SHEET 2 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10

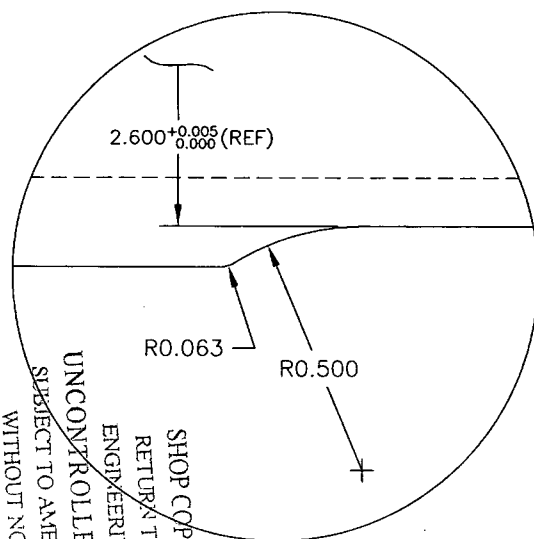
NO. 32684
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
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UNCONTROLLED COPY

RELEASED
07.04.24
PER ECN 885

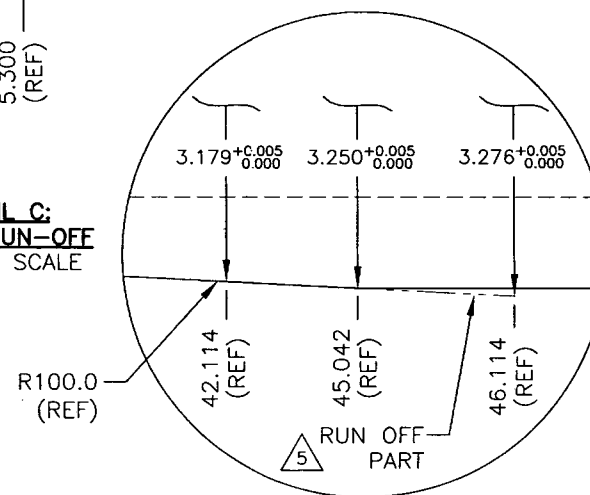
DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF TRANSITION
SCALE 4:1



DETAIL C: TAPER RUN-OFF
NOT TO SCALE



NO. 32684
WORK ORDER
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

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DESIGN
PH

DRAWN BY
PH

CHECKED
PH

APPROVED
PH

DATE
07.03.08

DART

DART AEROSPACE LTD.
HAMMERSBURY, ONTARIO, CANADA

DRAWING NO.
D212-664-241

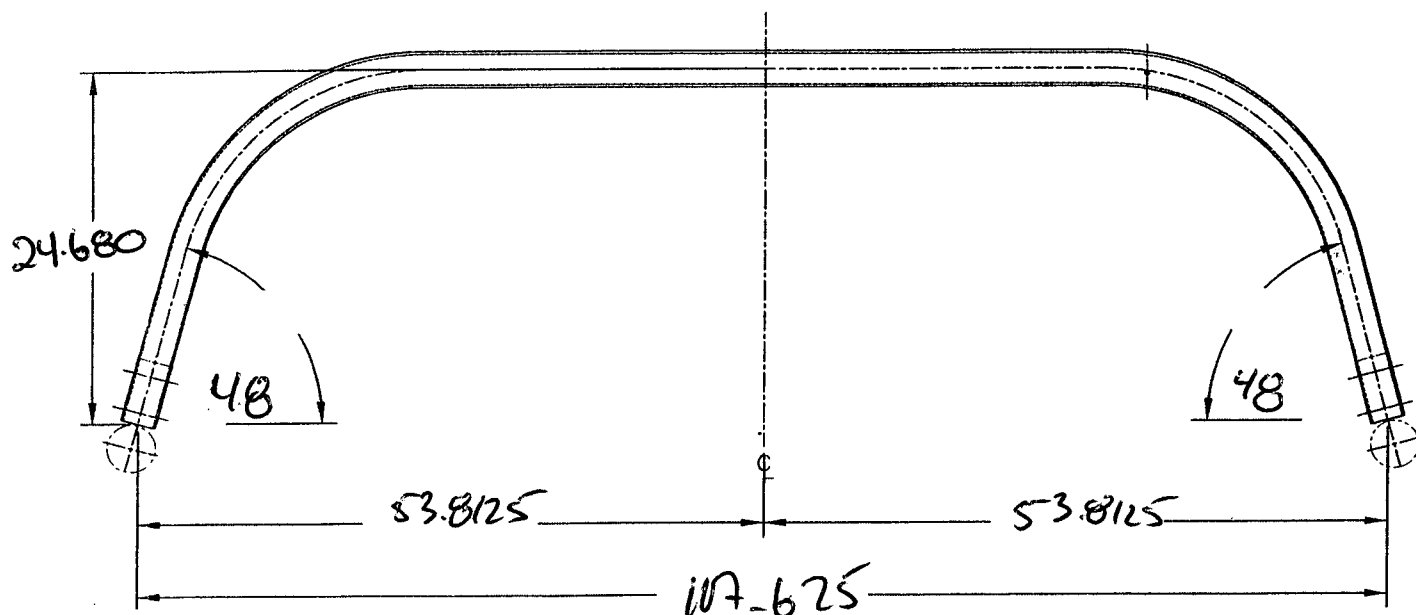
REV. C
SHEET 3 OF 3

TITLE
CROSSTUBE ASS'Y (205/212 HI AFT)

SCALE
1:1

DART AEROSPACE LTD		Work Order:	32684
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Tube is .380" high over nominal.
See Approval Attached

QC15 Inspection :	<i>[Signature]</i>
Date	07.07.25

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	

Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Wednesday, July 25, 2007 11:36 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: FW: NCR D212-664-201 B32684
Attachments: drawing.jpg

Jason,

D212-664-201 B32684 is acceptable per attached sketch.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Wednesday, July 25, 2007 7:00 AM
To: 'David Shepherd'
Cc: 'L Lacelle'
Subject: NCR D212-664-201 B32684

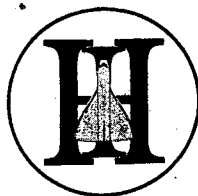
I'm guessing that the middle was slightly over bent on this guy. It still seems to follow the top of the board reference drawing. As you can see the tube is 0.380" over nominal on the height, and the angles are slightly below. Is it worth while to bend it in a little more? This would really make it high then. Or is this acceptable as is. I will be seeing this tube in a table set-up some time today.

jmurdoch@dartaero.com
Q.C. COORDINATOR

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.14/912 - Release Date: 7/22/2007 7:02 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.476 / Virus Database: 269.10.14/912 - Release Date: 7/22/2007 7:02 PM

7/26/2007



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lépine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37124

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (2) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-201 S/N's B32684.

Qty (1) P/N D412-664-245 S/N's B30935.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (2) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(2) cross tubes inspected. (2) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

B. Vulpillet

DATE August 13, 2007

INSPECTION
STAMP(S)

N/R

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00004338

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

29

Date: Friday, 5/25/2007 12:52:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number : 32684	
Estimate Number : 10257	
P.O. Number :	Part Number : D212664201
This Issue : 5/25/2007 S.O. No. :	Drawing Number : D212-664-241 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : C
Previous Run : 32683	Material :
Written By :	Due Date : 7/15/2007 Qty: 1 Um: Each
Checked & Approved By : <u>HA 07.05.28</u>	
Comment : Est Rev:E 04.02.16 Reformat K/DS	
Est Rev:F 06-03-29 Remove Coments on Pick List JLM	
Est Rev:G 07-04-30 As per Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

07.06.14

2.0	D6006129	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

1	D6006-129	Crosstube	
---	-----------	-----------	--

Check OD = 3.250"; ID = 2.220"

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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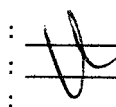
Comment: INSPECT ALL DIM TO DIM SHEET

INSPECTION ONLY

Dart Aerospace Ltd.

Date: Thursday, 10/01/2008 9:07:57 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D212-664
Job Number	: 36700		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 10/01/2008 S.O. No. :	Drawing Number	: ECN 1103
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 17/01/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK:

(17) -4 D212-664-101

-4 D212-664-201

✓ D412-664-203

35872-35871-35539
35929-35928-35870-35873-35927-35541-
32681-32684-32680-34586-32151
35725-35056-35106

ADD NEW PAPERWORK TO KITS IN STK
FAA STC: SR01298NY, PER ECN 1103

RETURN TO STOCK

17x 8/1/11 SCP

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.26.11